

Order ID 74252

September 27, 2011 1:02:49 PM



Page 1

Item ID: D4131-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Base Assembly

Start Date: 9/27/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/6/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: W

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4131

B

100

0.00



Waterjet

0.00

FLOW CNC Waterjet

304 .050

Memo

1-Cut D4131-3 as per Dwg

Dwg Rev: BProg Rev: B

2-Deburr if necessary

B11-10-14

(18)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

0.00

Quality Control

Memo

B11-10-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






NOTE: Date & initial all entries

Work Order ID 74252






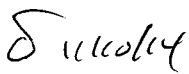


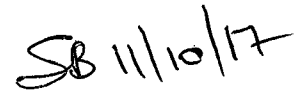


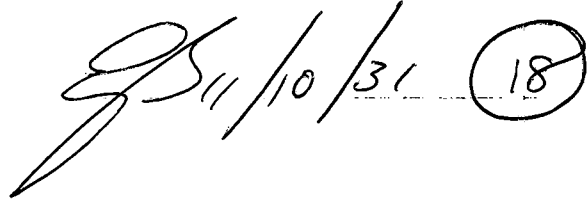
Page 2

Tuesday, September 27, 2011 1:02:49 PM

Item ID: D4131-045 Accept  Setup Start 
Revision ID: Stop 
Item Name: Base Assembly
Start Date: 9/27/2011 Start Qty: 10.00  Cust Item ID:
Required Date: 10/6/2011 Req'd Qty: 10.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
130  Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00							
140  Small Fab Small Fab	 Memo INSTALL LABEL PLATE AS PER DWG	0.00 0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74252

Tuesday, September 27, 2011 1:02:49 PM



Page 3

Item ID: D4131-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Base Assembly

Start Date: 9/27/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/6/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11/10/31 (18)

160 Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

11/10/31 (18)

170 QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/31

MF 11-10-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 1:02:46 PM

Page 1

Work Order ID: 74252

Parent Item: D4131-045

Parent Item Name: Base Assembly




Start Date: 9/27/2011


Required Date: 10/6/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 11.09.26 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4131-9 		Manufactured	No			140	Each	0.0000	1	10			
Label Plate M304S18GA 		Purchased	No			100	sf	288.0050	0.1613	1.697895			
304/316 .050 Sheet													
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				MAT020	288.005								
				113062	0.005								
				119032	288								
MS20615-3M3 		Purchased	No			140	Each	0.0000	2	20			
RIVET													

B74267 (182)  11/10/31

31-10-14

(18)

119035

M111650

(362)

11/10/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries

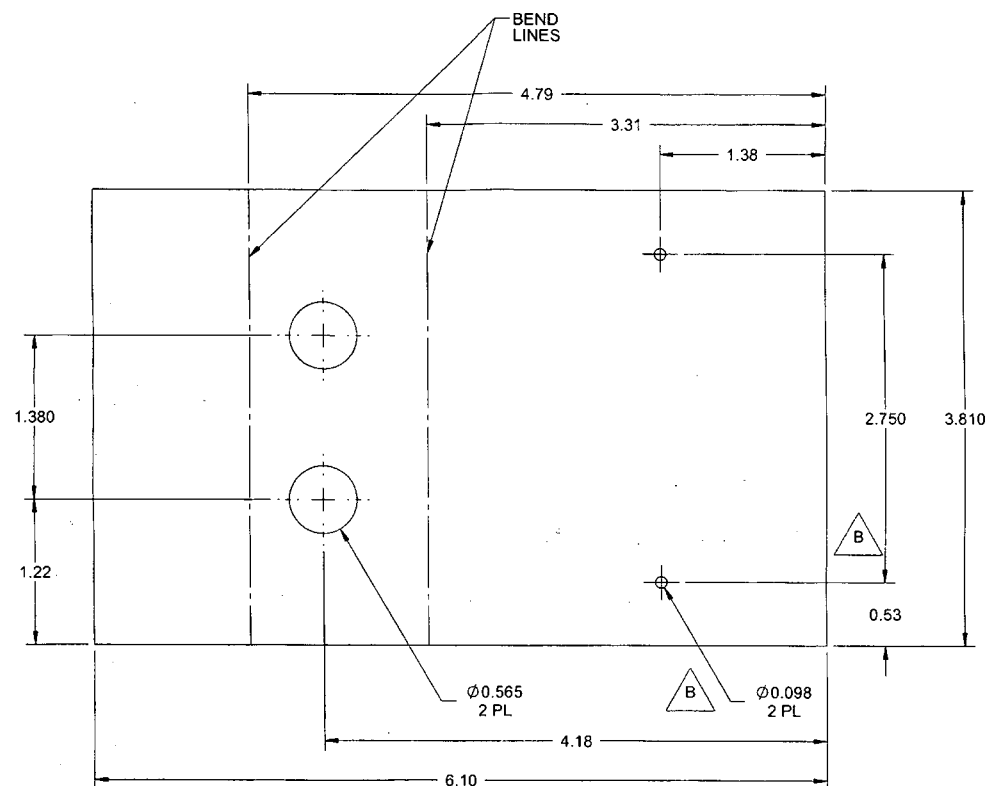
DART AEROSPACE LTD		Work Order:	79252
Description: Base		Part Number:	D4131-3
Inspection Dwg: D4131	Rev: A B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: <u>B</u>	Audited by: <u>S</u>	Preliminary Approval:
Date: <u>11-10-14</u>	Date: <u>11/10/14</u>	Date:

Rev	Date	Change	Revised by	Approved
A	10.10.25	New Issue	KJ 	



D4131-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC. M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4131	SHEET 7 OF 10
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MANIFOLD ASSEMBLY	NTS
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2011-09-21

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

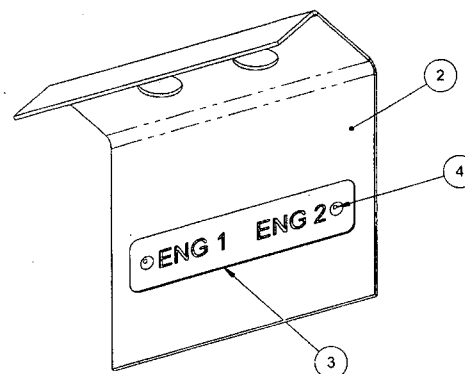
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D4131-045	BASE ASSEMBLY
2	1	D4131-3	BASE
3	1	D4131-9	LABEL PLATE
4	2	MS20615-3M3	RIVET



D4131-045 BASE ASSEMBLY



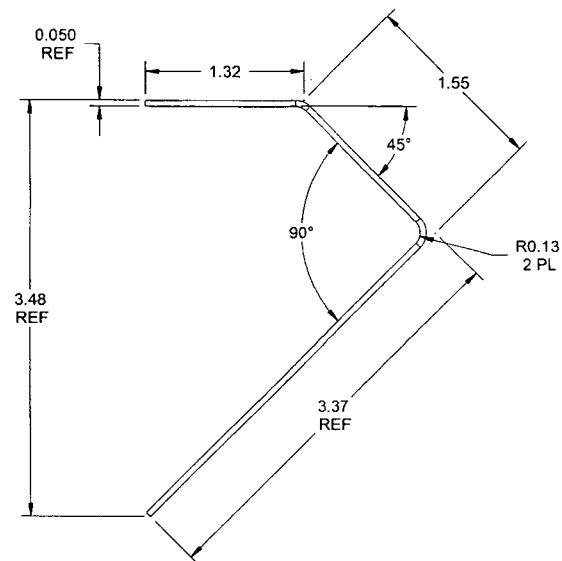
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.35 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
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MFG. APPR.	<i>[Signature]</i>	D4131	SHEET 3 OF 10
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2011-09-21

also 7/252



D4131-3 BASE
MAKE FROM D4131-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: MAKE FROM D4131-3F FLAT PATTERN
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

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2011-09-21

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DRAWN	RF	KENT, WA	
CHECKED	<i>MD</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>IS</i>	D4131	SHEET 6 OF 10
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